

Date: Wednesday, 3/29/2006 1:07:33 PM
User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 350/212/130 BASKET LID |
| Job Number : | 26391B | | |
| Estimate Number : | 10193 | | |
| P.O. Number : | N/A | Part Number : | D2512 |
| This Issue : | 3/29/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2512 REV D2 |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 26390B | Drawing Revision : | D2 |
| | Type : | Material : | N/A |
| | LARGE FAB ASSY | Due Date : | 4/5/2006 |
| Written By : | <i>See COMMENT BELOW</i> | | Qty: 1 Um: Each |
| Checked & Approved By : | | | |
| Comment : | Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 _ KJ/ RF | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 45.7594 f(s)/Unit Total: 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M100023

M 100282

185.4" ~~100282~~
CPL 06.04.09M100138 ~~100138~~

| | | |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

CPL B26382

CPL 06.04.09

| | | |
|-----|-------|---------|
| 3.0 | D2506 | Placard |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

B24875

CPL 06.04.10



| | | |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

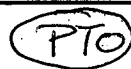
Qty Part Number Description

2 D2327-1 Bushing

Batch

B24873

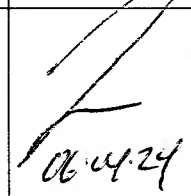
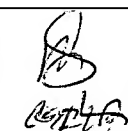
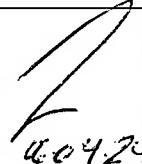
CPL 06.04.10



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-----------------|-----------------------|----------------------------------|-----------------------------|---|-----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-04-11 CPL | 4.0 4.0 | INSTAL ON WRONG SIDE | G 10 GARD | TAKE PIECE OFF AND PUT A NEW ON. ON TAKE 1 NEW D2327-1 | CPL 06-04-11 |  06-04-24 |  06-04-24 |  06-04-24 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 26391B

Part Number: D2512

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|-------|
| 5.0 | D22321 | Hinge |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | D2232-1 | Hinge plate | 3 23445 |

CPL 06.04.10

| | | |
|-----|-------|------------------|
| 6.0 | D2581 | Mounting Bracket |
|-----|-------|------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|---------|
| 2 | D2581 | Mounting Bracket | 3260204 |

CPL 06.04.11

| | | |
|-----|--------------|--------------------------|
| 7.0 | M304EX07516F | Expanded Metal Flat Stai |
|-----|--------------|--------------------------|



Comment: Qty.: 18.0000 sf(s)/Unit Total: 18.0000 sf(s)

Pick:

| Qty | Part Number | Description | Batch |
|-------|----------------|----------------|---------|
| 18 sf | M304EX0.75-16F | Expanded Metal | 1100722 |

CPL 06.04.21

| | | |
|-----|-------------|------------------------------|
| 8.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

CPL 06.04.24

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.

EC130 Basket only

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | D2012-117 | Clevis | |

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/05/04

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: 350/212/130 BASKET LID

Job Number: 26391B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD

06-04-24

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/28 (1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M14507

DL 06/04/30 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-02 (1)

Job Completion



Inspection Level 21

DL 06/05/04 (1)
U 06-05-04

Dart Aerospace Ltd

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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